

Shp 13/04

Work Order ID 57586



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April 9, 2010 11:21:58 AM

Item ID: D3608-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lower Doubler

Start Date: 4/09/10 Start Qty: 4.00



Cust Item ID:

Required Date: 4/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3608	Rev B								

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

RB 10-4-12

(6)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

RB 10-4-12

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sub 1064/12

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57586

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging	Identify as per dwg & Stock Location: <u>175</u> Memo	0.00 0.00							
160 QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Packaging									
Quality Control									

10/4/22 *(C)*

10/04/23 *JD*

MF
10-4-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 9, 2010 11:21:57 AM

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Work Order ID: 57586



Parent Item: D3608-1



Parent Item Name: Lower Doubler

Start Date: 4/09/10

Required Date: 4/13/10

Comments:

IPP Rev:A New Issue 07-03-26 JLM

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 08-10-15 preliminary issue DD verified by:EC

IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP

Rev:D 10.02.16 rev.B as per dwg DD verified by:EC

M304S20GA

Purchased

No

100

sf

79.0000

3.1124

S



304/316 .040 Sheet

B 10-472

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT20

79

112885

15

113062

64

112885

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 57586
Description: LOWER Doubler		Part Number: D3608-1
Inspection Dwg D3608-1, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

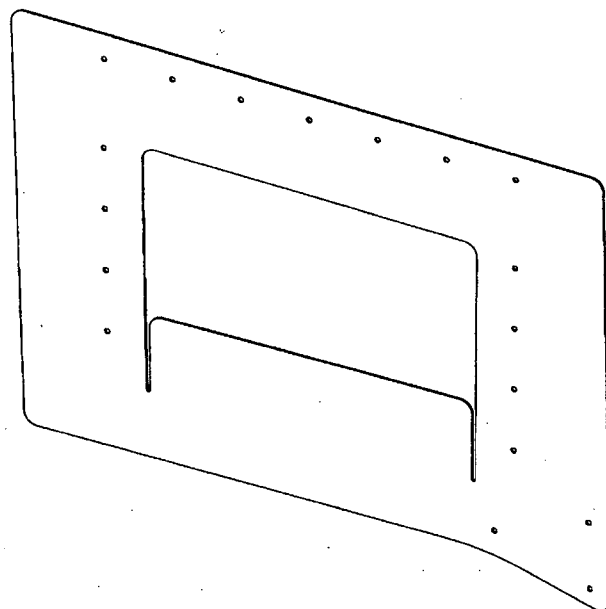
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .021	.101	✗			
1.83	± .030	1.810	✗			
.50	± .030	.499	✗			
11.63	± .030	11.626	✗			
8.100	± .010	8.104	✗			
1.350	± .010	1.354	✗			
2.51	± .030	2.513	✗			
2.06	± .030	2.060	✗			
8.90	± .030	8.888	✗			
3.750	± .010	3.748	✗			
1.250	± .010	1.247	✗			
.400	± .010	.399	✗			
1.350	± .010	1.347	✗			
.345	± .010	.343	✗			
1.875	± .010	1.877	✗			
.423	± .010	.423	✓			
6.42	± .030	6.417	✗			
2.43	± .030	2.433	✗			
2.90	± .030	2.902	✗			
1.34	± .030	1.343	✗			
8.44	± .030	8.428	✗			
.75	± .030	.754	✗			
2.49	± .030	2.499	✗			

Measured by: KB
Date: 10-4-12

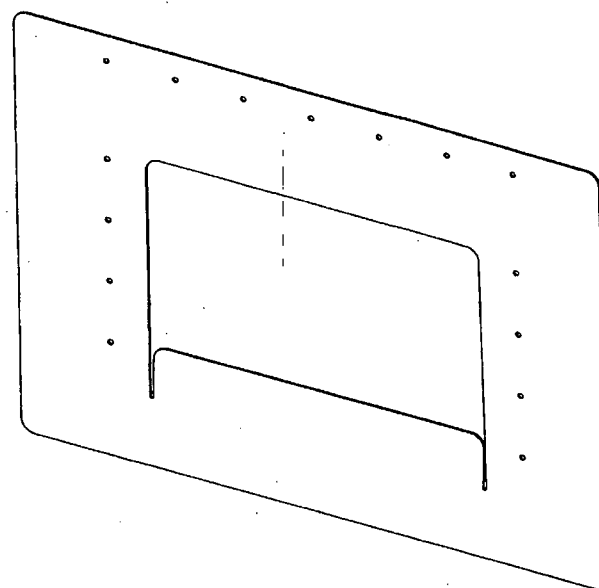
Audited by: S
Date: 10/06/12

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3608-1 LOWER DOUBLER



D3608-3 UPPER DOUBLER

also 57506

RELEASED
2010-02-10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.80 lbs EACH

B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARD; ELIMINATED D3608-1F/3F; DELETED BENDING DETAILS. REASON: D3608-1-3 NOW SOLD TO CUSTOMERS UNBENT PER PART#09-097.		MB	10.02.05
A	NEW ISSUE		MB	07.04.11
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD		REV. B	
DRAWN	HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 3	
CHECKED	DRAWING NO. D3608		SCALE	
MFG. APPR.	TITLE DOUBLER		NTS	
APPROVED	DATE 10.02.05		COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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